

**Work Order ID 52662**

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October 5, 2009 2:53:47 PM

Item ID: D3066-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacer

Start Date: 06/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: *PL*Date: *09-10-5*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3066	Rev B

100



FLOW WATER JET

Waterjet

Memo

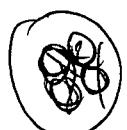
0.00

*RB 9-11-2*

FLOW CNC Waterjet

1-Cut as per Dwg D3066  
Deburr if necessary

0.00

 Dwg Rev: *B*  Prog Rev: *B*  2-

110



QC2- Inspect parts off machine FAI/FAIB

0.00

*RB 9-11-2*

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

*→ Soñulor*

QC

Memo

0.00

Quality Control

*coñulor*  
*CEP*


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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

JH

09/11/04

87

P

Hand Finishing

140



QC3- Inspect Part Finish

0.00

BK 09-11-5

87

QC

Memo

0.00

Quality Control

150



Identify as per dwg &amp; Stock Location: Steven D.

0.00

Packaging

Memo

0.00

Packaging

Peg/11/05 (FJ)

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Start Date: 06/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

09/11/06

MF  
09-11-05

**Picklist Print**

Page 1

October 5, 2009 2:53:47 PM

Work Order ID: 52662



Parent Item: D3066-1RevB



Parent Item Name: Spacer

Start Date: 06/10/2009

Required Date: 13/10/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080 		Purchased	No			100	sf	302.7094	3.9789	8.6645 		13/10/2009

6061-T6 .080 Sheet

Warehouse      Loc Qty      Loc CodeLocation

## Main Warehouse

MAT	302.7094	
107904	0.02	
110254	2.5	
110630	38.0926	
112040	0.0437	
112141	33	
112512	37.0531	
112763	192	

108433  
16254
 $108433 \times 20 = 21686.60$   
 $16254 \times 38 = 61765.20$   
 $108433 \times 18 = 19518.14$   
 $16254 \times 11 = 17879.44$

DART AEROSPACE LTD	Work Order:	52662
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	9-11-2	Date:	09/14/02	Date:	N/A

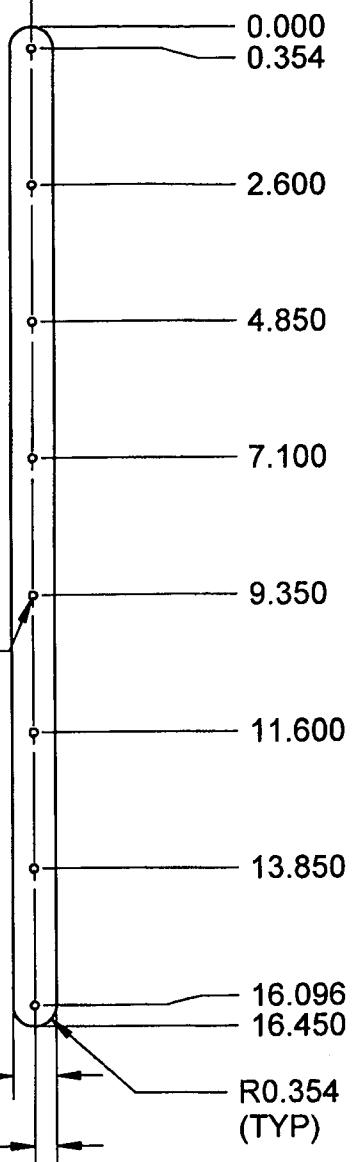
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	<i>[Signature]</i>
B	06.06.23	Dwg Rev. changed	KJ/JLM	<i>[Signature]</i>

**DART**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. <b>D3066</b>
PH	MM	REV. B
DATE	06.05.29	SHEET 1 OF 1
		SCALE 1:3
A	02.09.11	NEW ISSUE
B	06.05.29	ADD 6061-T6 MATERIAL

**RELEASED**

06.06.20 MM

**D3066-1 SPACER**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK  
(REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER  
NO. 52062  
BL09-10-5